Work Order ID 59976

Tuesday, June 22, 2010 10:15:26 AM



Page 1

Item ID:

D206-667-103

Accept

Setup Start



Revision ID:

Item Name:

Crosstube Fwd

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Date:

Date: (0-(-2)

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID Operation

Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Reject Accept Qty **Qty**

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D206-667-143

Rev C

100

DC

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-103 CHG004

110

Packaging Packaging

Pick Kit

Packaging

Memo

0.00

0.00

120

CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES Memo

0.00

0.00

Bend tube as per Dwg D206-667-143 using CNC bender program

D MB 10-06-28

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W/O:			WO	RK ORDER CHANG	ES			,	,
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	By Date Qty			Approval QC Inspector
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Start Date: Required Date: Reference:	6/22/2010 : 7/20/2010	Start Qty: 1.00 Req'd Qty: 1.00	!		Cust Item Customer:	(D:				•		A14	
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Dan Aerospace Liu	t Aerospace	Ltd	
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W/O:			WORK ORDER CHANGES								
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Work Order ID 59976

Tuesday, June 22, 2010 10:15:26 AM



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Item ID:

D206-667-103

Accept

Setup Start

Stop

Start

Stop



Revision ID:

Item Name: Crosstube Fwd

Start Date: 6/22/2010

Start Oty: 1.00

Required Date: 7/20/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

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Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Accept **Qty**

Reject **Qty**

Run

Reject Number Stamp

Insp.

Sequence ID/ Work Center: ID

140



Crosstubes

Crosstubes

Description

Crosstubes

Operation

Memo

0.00

0.00

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff(Donot engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

-Awm 10-06-29

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Work Orde Tuesday, June 22									1					Page 4
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Sequence ID/ Work Center ID 150)	Operation Description Crosstubes Chemical Cor	nversion		Set Up/ Run Hours	То	ol ID T	ool#	Plan Code	Accept Qty	Rej Qty			Insp. Stamp
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160 1 11111 11111111111111111		QC3- Inspect Part Finish			0.00	1			į					
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170 		QC5- Inspect part comple	eteness to step o	on W/O	0.00	1	. 1			4)			
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Work Order ID 59976

Tuesday, June 22, 2010 10:15:26 AM



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Item ID:

D206-667-103

Crosstube Fwd

Accept



Setup Start

Stop



Item Name: **Start Date:**

Required Date: 7/20/2010

Revision ID:

6/22/2010

Start Oty: 1.00

Req'd Qty: 1.00



Date:____

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Run Start

Stop

Sequence ID/ Work Center ID

180

Outsource2

Outsource process - NDT

Operation Description

Outsource process - NDT per OSI038 4.1

Set Up/ **Run Hours**

0.00 PN:12200

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

CROSSTUBES

Memo

7/0:12212

CX 10/7/1 c710/7/7 0

190

Packaging

Packaging

Memo

0.00

0.00

Packaging

Ensure copy of NDT results attached to work order.

200

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10-07-14

W/O:			WOI	RK ORDER CHANG	GES						,
DATE	STEP	PROCI	EDURE CHAN	GE		Ву	Date	Q	у	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Tuesday, June 22, 2010 10:15:26 AM

Item ID:

D206-667-103

Accept



Setup Start

Stop



Revision ID: Item Name:

Crosstube Fwd

Start Date:

6/22/2010

Start Oty: 1.00

Req'd Oty: 1.00

Operation

Description



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Accept

Otv



Required Date: 7/20/2010

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

210

SprayPaint Spray Painting

SprayPaint

Memo

0.00

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 9100 Fininsh Time: (3) 00

PAINT:

Start Time: 2:00 Finish Time: 3: 30

220

QC14- Inspect Spray Paint

0.00

M 10 07 15 0

Memo

0.00

Wrap in plastic bag to protect from scratches

Quality Control

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Work	Order	· ID	59976
Tuesday,	June 22,	2010	10:15:26

Quality Control



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Tuesday, June	22, 2010 10:1	5:26 AM									'	
Item ID: Revision ID:	D206-667-1	03		Accept					Setup	Start		
Item Name:	Crosstube Fw	⁄d			1					Stop		
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	QC:		Date:	SPC (Y/N):	D	ate:				Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Crosstubes		Crosstubes Memo		0.00								-
Crosstubes		1-Install sup 015. Let cur holes should A/R Magno 2-Install sup 100 in lb	re for 12h after installed be facing up. Shond 6398:	06-667-143) .06" thick layer of magnobond ation and prior to packaging. Note that the packaging of the packa	ue clamps to 80	C (0° M 10-0	·87·19	O				
240 		QC5- Inspect part comp	leteness to step on W/	O.00 O.00	lorto;			@				

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W/O:			W	ORK ORDER CHANG	ES					.*	
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Work Ord Tuesday, June 2												Page 8
Item ID: Revision ID: Item Name: Start Date: Required Date:	D206-667-10 Crosstube Fw 6/22/2010 7/20/2010			Accept	Cust Item Customer	ID:			Setup	Start Stop		H
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	F	Date:	_ 		Run	Start Stop	1	
Sequence ID/ Work Center II 250 Packaging Packaging	D	Operation Description Pick Kit Memo		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accer Qty	Ot Rej	y N	Reject	Insp. Stamp
QC Quality Control		QC4- 100% Inspect kits Memo	for completeness	0.00	1ster			Æ)			

270

Packaging

Packaging

0.00

0.00

Memo

Packaging

Identify and pack for shipping as per PPP D206-667-103 Location:

PPP Rev:

W/O:			V/	ORK ORDER CHANG	iES			1			
DATE	STEP	PRO	CEDURE CH	ANGE	1	Ву	Date	c ty	/	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 59976

Tuesday, June 22, 2010 10:15:26 AM



Page 9

Item ID:

D206-667-103

Accept

Date:

Date:

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Crosstube Fwd

6/22/2010

QC:

Start Qty: 1.00

Required Date: 7/20/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

QC21- Final Inspection - Work Order Release

Date:

SPC (Y/N):

Run

Stop

Start





Sequence ID/

Work Center ID

280

Quality Control

Memo

Set Up/ **Run Hours**

Tooling:

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp.

Number Stamp

W/O:			W	ORK ORDER CHANG	GES					,	
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Picklist Print

Tuesday, June 22, 2010 10:15:30 AM

Work Order ID: 59976

Parent Item:

D206-667-103

Parent Item Name: Crosstube Fwd



Start Date: 6/22/2010

Required Date: 7/20/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: $F \square 05.09.01 \square Add$ holes for compatibility with Bell Skidtubes $\square KJ/JLM$

IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:

IPP Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified by: EC

IPP Rev:I 08-12-15 add magnobond DD verified by:EC IPP Rev J 09.01.06 ECN 08-562 EC verified by: DD

IPP Rev:K 09-01-19 as per DSI9439 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D206-667-103TRN	131 1 44 144 14 1 1 41 141 141 1	Manufactured	No			110	Each	2.0000		1 M 8	10-0	85-0
				Location LG	55831 55832	<u>Loc (</u>	Oty 2 1 1 1 1	Loc Code	-	(X)	-	
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D2873-045 Nut Plate Assembly		Manufactured	No			230	Each	44.0000	2	2		
				<u>Location</u> LG	53967 53968	<u>Loc (</u>	Oty 44 5 20	Loc Code		/	w(-	10:07-19

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RUBBER CUSHION .63" x 3.95" (4) MS20601-AD4W8 Purchase									
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W/O : 5	9976	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12075		used 03695-063-570 trimmed to size to replace 03695-063-390 (no stock	RT	1007-5			5
		D3695-067-530351776					10/20/20
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Part No: 206-667-103 PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
Resolution:	Disposition:	QA: N/C Closed:	Date:	

	WORK ORDER NON-CONFORMANCE (NCR)						,
DATE STEP	Description of NC	Description of NC Corrective Action Section B				Approval	Approval
STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Chief Eng	QC Inspector	
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Picklist Print Page 3 Tuesday, June 22, 2010 10:15:30 AM Work Order ID: 59976 D206-667-103 Parent Item: Parent Item Name: Crosstube Fwd Required Date: 7/20/2010 Start Date: 6/22/2010 Start Qty: 1.00 Required Qty: 1.00 MS21920-20 Purchased No 230 Each 101.0000 (0-07-(5) Clamp (per MIL-DTL-8783C) Location Loc Qty Loc Code LG 101 24 112624 3 112793 114687 50 114779 24 · AN5-30A Purchased No 250 Each 112.0000 Location Loc Qty Loc Code ST339 112 M1/2933 112933 37 114437 25 114941 50 AN5-32A Purchased No 250 Each 178.0000 Bolt Location Loc Qty Loc Code ST340 178 113121 28 114056 100 114405 50 AN5-7A Purchased No 250 Each 206.0000 Location Loc Oty Loc Code ST337 206 113149 200 113226 6

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Picklist Print

Page 4

Tuesday, June 22, 2010 10:15:30 AM					\$			rage 4
Work Order ID: 59976								1
Parent Item: D206-667-103								
Parent Item Name: Crosstube Fwd		I IMMIIIM IMIM I	IEII SAFIA AIII IIBBIZ AIIIN EIIII IANI (HAI	A	l		art Date: 6/22/2010	Required Date: 7/20/2010
						S	tart Qty: 1.00	Required Qty: 1.00
AN960JD516 NAS1149D0563J	Purchased	No		250	Each	0.0000	18 18	
Washer					i		m.	1/9742
AN970-4	Purchased	No		250	Ėach	93.0000	12 12 ~	
Washer								
vv astici			Location	<u>Loc</u>	Qty.	Loc Code		
			ST349		93			- 0.
MS21042L5 /			112991		93		Mila	<u>9</u> 7/
((BC)(C))	Purchased	No		250	Each	681.0000	4 4	
>								1/(10/1/21
			<u>Location</u>	Loc	Oty	Loc Code		() /
			ST139		500	200 0040		
			114813		500		M1148	<u>7</u> 3
			ST300		18İ			<u> </u>

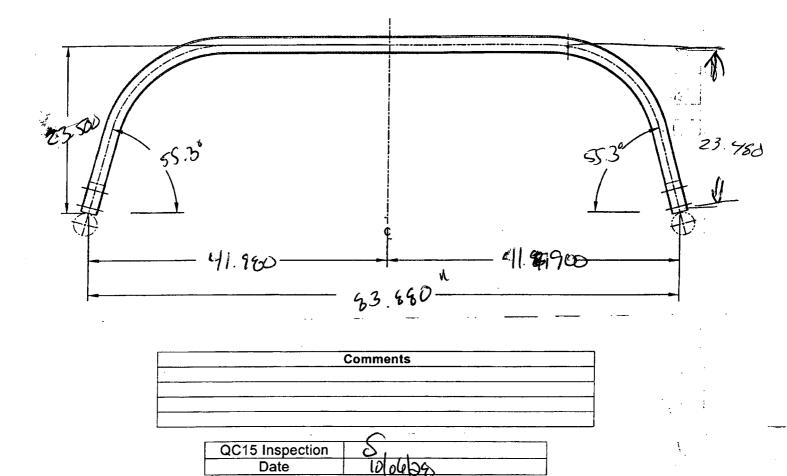
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N/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector		
							1	Prod Mgr			
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	1	•									
		PAR #:	Fault Cat	tegory:	NCR: Yes	No DQA:		Date:			
	Resolution:						Date:				
NCR:		V	VORK ORI	DER NON-CONFORM	IANCE (NC	R)		· ·			
DATE	STEP	Description of NC		·····	A size D see it			Approval	Approval		
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		С	Chief Eng	QC Inspector		
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DART AEROSPACE LTD	Work Order:	39976
Description: Crosstube High Fwd (206L)	Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10



Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	1
В	09.06.26	Dimensions updated per Dwg Rev C	KJ	1
С	09.10.22	Minimum height dimension revised	KJ	1/2
				· / _

Dart Ae	rospac	e Ltd					•			
W/O:				WC	RK ORDER CHANGI	ES				
DATE	STEP		PR	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No);		PAR #:	Fault Cated	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	lesolu	tion:	Disposition	1:	QA: N/C Closed: Date:				
NCR:				WORK ORDE	ER NON-CONFORMA	NCE (NC	R)		*, <u>, </u>	
DATE	0750		Description of NC		Corrective Action Section	on B	Verifi	cation	Approval	T
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	ion C	Chief Eng	Approva QC Inspecto
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Item	Qty -143	Part Number	Description
1	х	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	. 1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120- 023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6002-115 FINISHED LENGTH = 104,98±0,020

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

. SHOP COMY RETURN TO ENGINEERING, UNCONTROLLEGICTY SUBJECT TO ANDTONE A WITHOUT NOT F WORK Children BS10-6-22



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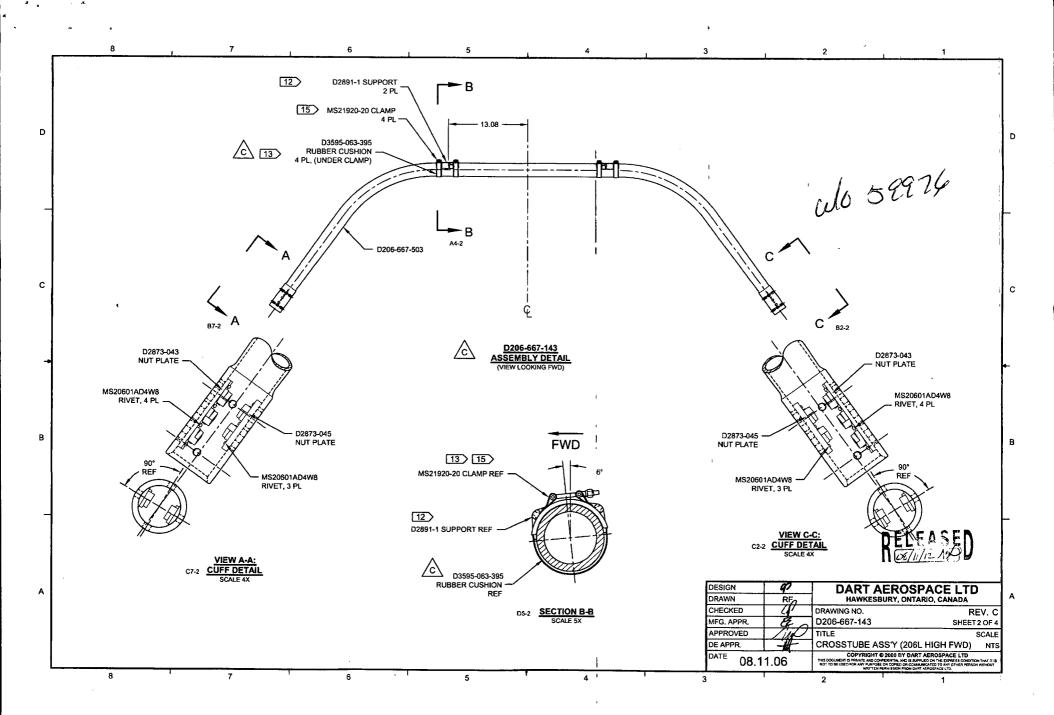
C	REORG TO CUP D3595-C REMOV RELOC	EVISE GENERAL NOTES/PART LIST (ZN D7-1); ECRGANIZED VIEWS AND REFORMATTED DRAWING O CURRENT STANDARDS. 3995-063-399 WAS D2856-400-694 (ZN D8-2 & A5-2); EMOVED REF, & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); ELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED URNING DETAIL & UPDATED TOLERANCE TO SHEET 4. DD HOLES AND NUT PLATES FOR COMPATABILITY PH 05-07-26								
В		DLES AND NUT HT/AA SKUDTI	PH	05.07.26						
A	NEW IS	SSUE		CP	00.11.17					
REV.	L		DESCRIPTION	BY	DATE					
DESIGN		P	DART AEROSP	ACE	LTD					
DRAWN		RF ₂	HAWKESBURY, ONTAR	O, CAN	ADA					
CHECKE	ED	ar -	DRAWING NO.		REV. C					
MFG. AF	PPR.	80	D206-667-143	SHEET1 OF 4						
APPRO	VED .	/ill	TITLE SCAL							
DE APPI	R.	CROSSTUBE ASS'Y (206L HIGH FWD) NTS								

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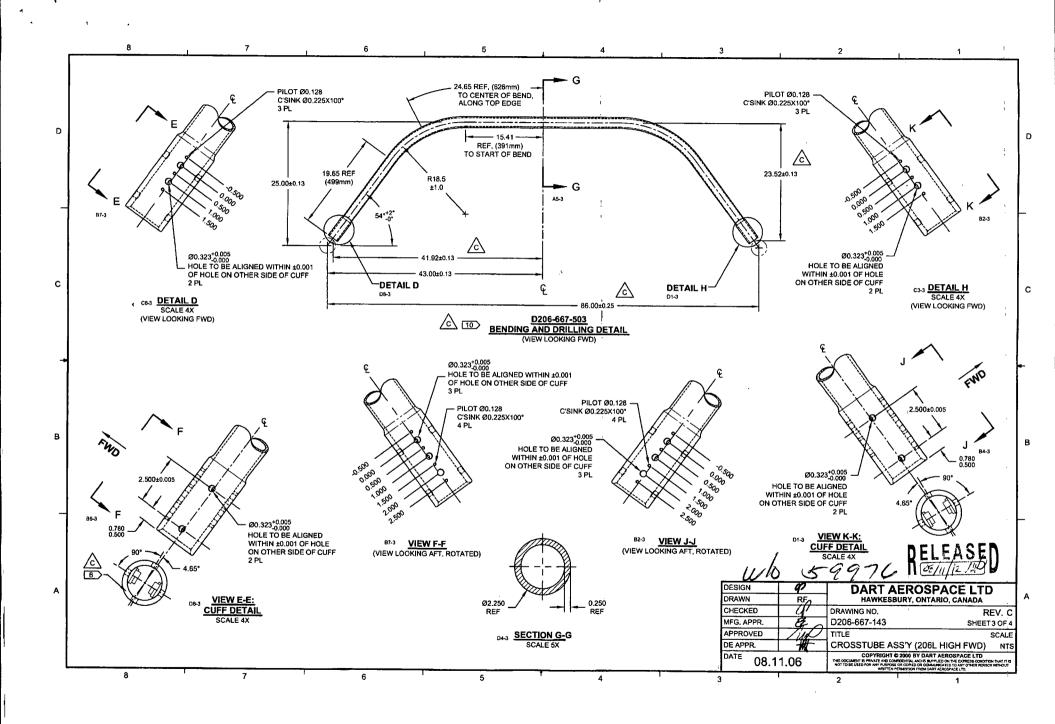
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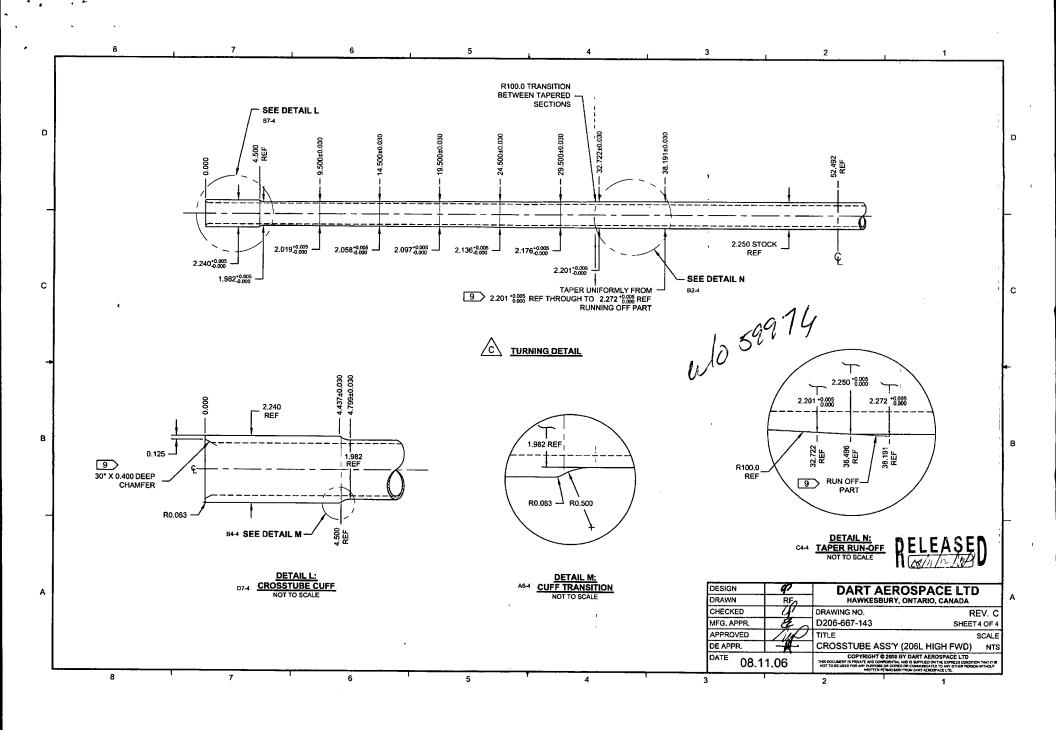
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David No.					NOD	N	- 50		Datas		
Part No:PA								II.			
	R			Disposition: QA			ed:		Date:		
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCR)					
DATE	CTED	STEP Description of NC Section A	Corrective Action Section B			Veri		Verification	Approval	Approval	
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector	
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W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr Approval Chief Eng / Prod Mgr Approval Chief Eng / Prod Mgr QC Inspector Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date:	Dart Ae	rospace	e Ltd						
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date:	W/O:			W	ORK ORDER CHANGE	ES			•
Resolution: Disposition: QA: N/C Closed: Date:	DATE	STEP	PRO	CEDURE CH	Ву	Date Qty	Chief Eng /	Approval QC Inspector	
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Resolution: Disposition: QA: N/C Closed: Date:									
WORK ORDER NON CONFORMANCE (NOD)	Part No	:	PAR #:	Fault Cat	tegory:	NCR: Yes N	lo DQA:	Date: _	
WORK ORDER NON CONFORMANCE (NCD)		R	esolution:	Dispositi	ion:	QA: N/C Clo	sed:	Date: _	
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DATE STED Description of NC Corrective Action Section B Verification Approval Approval	54		Description of NC				Verification	Annroval	Approval
DATE STEP Description of NC Section A Section A Section A Section C Section	DAIE	SIEP							



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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo DQ A	\ :	Date:	
		esolution:								
NCR:	·	1	WORK ORD	ER NON-CONFORMA	ANCE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section		2: 0	Verific		Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector



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	Re	esolution:	Disposition);	QA: N/C C	losed:		Date: _	<u></u>
NCR:	*			ER NON-CONFORMA					
DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
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ACUREN	LIQUID PENET	RANT TEST REPORT	, 2002
			Page / OF / ·
CLIENT DA	RT AFROSPACE	DATE JU192-2010	TIME AM TE PM D
ATTENTION	LINDA JEHANTEL	ACUREN JOB NO. 188-10-	0776
ADDRESS 1270	ABERDEEN ST.	PO/WO No.	
MACO	KESBCRT, ON.	WORK LOCATION MAIN SHOP - A	AWKES BUILY
_K6	H IK7		REV./DATE 2007
PROJECT	•	TUBES & WICHINED PA	27>
	Four CROSS TUBES		
	ELEVEN MACHINED	STaDS.	
JOB DESCRIPTION	PROCEDURE NO. LT 2002 REV./DATE	TECHNIQUE NO. LTTERY 2	
PART NO.			MESS ALUDINE -
- 2	PLOURESCENT LIQUIL		A aminum
	Two CARRED OUT	100% EXTERNAL.	
TEST DETAILS	FLUORESCENT UVISIBLE	₩ATER WASH ☐ SOLVENT REMOV	ABLE POST EMULSIFIED
METHOD FAMILY BRAND	TWAFLUX	BLACK LIGHT S/N /6459 OUTPUT > 1000 p	
PENETRANT ZL (7 MINIMUM DWELL TIME 4510 MIN.	LIGHTING EQUIP. FLASHLIGHT TROUBLELIGHT	
PENETRANT REMOVER DEVELOPER SKIN	20 MINIMUM DRY TIME >10 MIN. \$2 MINIMUM DWELL TIME 10 MIN.	OTHER 648 IN O LIGHT METER S/N 109 E866	CAL DUE DATE OCT. 19
	Non Aqueous	, 0, 00 00	2010
TEST SURFACE	A. A. Maria	(SV. M. Co. Waller Co. Co. Co. Co. Co. Co. Co. Co. Co. Co.	P. O. S. D. D. S. Marris
SURFACE CONDITION SURFACE TEMPERATURE	AS GROUND ☐ AS WELDED < - 4°C/ 20°F ☐ - 4°C/ 20°F TO 10°C/50	☑ MACHINED □ SHOT BLASTED ☑ 10°C/50°F TO 52°C/125°F	☐ CLEAN BARE METAL ☐ > 52°C/125°F
	METRIC IMPERIAL)	3500/50	
	-W.O. 59668 / .		
	3E-W.O. 59975	INDICATIONS ON CROS	S TUBES.
·		W.O. # 59975 W.O. # 59976	
1 - (1/03) 1/4	BE-W.O. 59976) V BE-W.O. 58387 V	W. C. # 58388 IN PROCESS TO BE K	PencieD
		The sold the second marked at the R	
1 -CKOSS 70	BE-W.O. 58388 TV		
that all descriptions, comments and expre representations or warranties. Acuren G data or other information provided by Ac Standard of Care	erform services extends only to those services provided for in writing. Und essions of opinion reflect the opinions or observations of Acuren Group Inc. roup Inc. is not assuming any responsibilities of the owner/operator and the uren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of ten Group Inc. uses the degree, care and skill ordinarily exercised under sin troup Inc.	based on information and assumptions supplied by the owner/operator and owner/operator relgins complete responsibility for the engineering, manufo the services referred to herein exceed the amount paid for such services.	are not intended nor can they be construed as icture, repair and use decisions as a result of the
SIGNATURES			
CLIENT REPRESENTATIVE	Jason Murdoch	DTR#	E63366
TECHNICIAN (SIGNATURE):	PRINT	REPORT	
NAME (PRINT):	M.W. ToHAS TON	2 ^{rto} TECHNICIAN	AME INITIALS
	CGSB Level SNT Level CGSB Le CGSB Reg. No 6666 CGSB Reg. No		



LIQUID PENETRANT TEST REPORT

P- 15181

ACUREN	CART TEOT RELOTT
	PAGEOF
CLIENT DACT A END STACE	DATE July 7-2010 TIME AM & PM 0
ATTENTION LINDA/CHANTEL	ACUREN JOB NO. 108-10-0777
ADDRESS 1270 ABEADEEN HANKES ONLY	PO/WO No.
ONT	WORK LOCATION WALL SHOP - HAWKESBURY
KOH 1K7	ACCEPTANCE STD. ASTU 1417 REV./DATE 2007
PROJECT F. P. I. W THICE	CROSS TUBES THAT HAD PREVIOUS
ITEM(S) EXAMINED INDICATIONS (SEE PSONT II I	5329) É FOUR CLOSS TUBES
JOB DESCRIPTION PROCEDURE NO. LTOO REV./DATE	TECHNIQUE NO. LT-FAH & REV./DATE
	MATERIAL STAWLESS STEELS THICKNESS ACIDINE
SCOPE WET FLOWESCENT &	IQUID PENET PANT ALMININ
INSECTION CARLES OUT 1	00% EXTERNAL
TEST DETAILS	
	WATER WASH SOLVENT REMOVABLE POST EMULSIFIED
	BLACK LIGHT S/N /6 45 G □ OUTPUT > 1000 µ W/CM2 □ AMBIENT < 2 fc LIGHTING EQUIP. □ FLASHLIGHT □ TROUBLELIGHT □ OUTPUT>100 fc @ SURFACE
	OTHER 64BINO
	LIGHT METER S/N 1078866 CAL DUE DATE OCT 18
DEVELOPER TYPE NON AQUEOUS AQUEOUS DRY TEST SURFACE	2010
	Machined Shot Blasted Clean Bare Metal
SURFACE TEMPERATURE 🔲 < - 4°C/ 20°F 🔲 - 4°C/ 20°F to 10°C/50°F	
RESULTS- (METRIC MPERIAL)	
2 - Closs Tube. W.O. 59975 VAT 4 - Closs Tube. W.O. 59976 VIV-07 1 - Closs Tube. W.O. 58388 V 1 - Closs Tube. W.O. 60145 V	NOTE: Closs Tubes - W.O. 59975 - H- W.O. 599-76 - W.O. 58388 WELL ON REPORT # 15329 INDICATIONS WELL FOCATED ALEAS OF INTELEST WELL
1 - Closs Tube W.O. 60146 / 1 - Closs Tube W.O. 59973 /	EXAMINED AT THIS TIME AND FOUND ACCEPTABLE.
Scope of Services The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under natural all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. has representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the or data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the Standard of Care In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similal implied, is made or intended by Acuren Group Inc.	sed on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as ener/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the e services referred to herein exceed the amount paid for such services.
SIGNATURES	. 2
CLIENT REPRESENTATIVE Lan-Littley	DTR# E63368
TECHNICIAN (SIGNATURE):	SIGNĂTURE REPORT
NAME (PRINT): Mike Johnston	REVIEWED BY: NAME INITIALS
CGSB LEVEL SNT LEVEL CGSB LEVE CGSB REG. NO (CGSB REG.	

DART AEROSPACE LTD.

REFERENCE ONL'S

IIN-D206-667 Page 14 of 14



5.0 **PARTS LIST**

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X								1	D206-667-011	SPACER BLOCK KIT
		Х								D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
			X							D206-667-015	NUT PLATE KIT (-201)
				X						D206-667-101	CROSSTUBE INSTALLATION,
					ŀ						206A/B HIGH FWD
				<u> </u>	X	1				D206-667-201	CROSSTUBE INSTALLATION,
	İ					,					206A/B HIGH AFT
						X				D206-667-103	CROSSTUBE INSTALLATION,
											206L/L-1/L-3/L-4 HIGH FWD
							X			D206-667-203	CROSSTUBE INSTALLATION,
											206L/L-1/L-3/L-4 HIGH AFT
								X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
							ļ		X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
				ļ		1					
1				1		•				D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2					1				ļ	D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3		I -				1				D206-667-143	CROSSTUBE ASSEMBLY,
							L				206L/L-1/L-3/L-4 HIGH FWD
4				1			1			D206-667-243	CROSSTUBE ASSEMBLY,
				ļ							206L/L-1/L-3/L-4 HIGH AFT
5								1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6									1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
					L						0.12222
10				*2	*2	*2		*2		D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12									*1	D2894-1	SUPPORT
13				*2	*2	*2		*2		D2856-400-694	ABRASION STRIP
14		L					*2		*2	D2856-400-773	ABRASION STRIP
15									*1	D2856-600-851	ABRASION STRIP
16				*4	*4	*4		*4		MS21920-20	CLAMP
17							*4		*4	MS21920-22	CLAMP
18									*2	MS21920-24	CLAMP
19				4	4	4		4		AN5-32A	BOLT
20							4		4	AN5-34A	BOLT
21				4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22				8	8	7 8	8	8	8	AN960JD516	WASHER
23									*2	D3190-1 /	CHAFING SHIELD
										1004.00	POLT
30	8							ļ		AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16						ļ			AN960JD416	WASHER COK ASSEMBLY
33	2							<u> </u>	1	D3193-041	SPACER BLOCK ASSEMBLY
- 10				*0		+0	+0	*0	*2	D2072 042	NUT PLATE
40		2		*2	ļ	*2	*2	*2	*2	D2873-043	NUT PLATE
41		2		*2	<u> </u>	*2	*2	_*2	*2	D2873-045	NUT PLATE
42			2		2					D2872-043	NUT PLATE
43			2	40	2	40	ļ			D2872-045	
44		10		10		10	4.0	10	10	AN5-7A /	BOLT
45		10	10		10		-10	10	10	AN5-10A	BOLT
46		4	4	4	10	4		4		AN5-30A	BOLT
47		4					4		4	AN5-32A	BOLT
48		18	18	10	12	10	10	10	10	AN960JD516 /	WASHER
49		4	4		6 -		I	l	l	MS21042L5	NUT (OR MS21042-5)

^{*}REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2

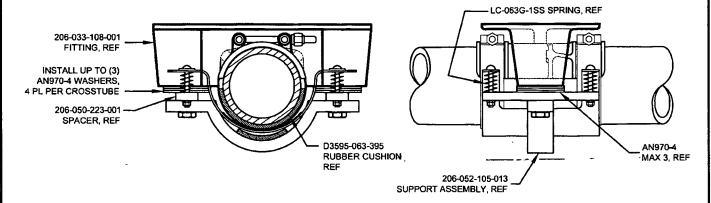
REF CANADIAN STC: SH01-5 REF FAA STC: SR01304NY REF EASA STC: EASA.IM.R.S.01179

PROBLEM:

FOR D206-667-103 CROSSTUBES (206L FWD) AT CHG 003 AND SUBSEQUENT (SEE DSI 9415) PROPER INSTALLATION OF THE OEM SUPPORT ASSEMBLIES MAY BE IMPOSSIBLE DUE TO THE ADDITIONAL THICKNESS OF THE DART D3595-063-395 RUBBER CUSHIONS. THE 206-052-105-013 SUPPORT ASSEMBLY (OR EQUIVALENT) MAY SIT TOO HIGH RELATIVE TO THE 206-033-108-001 FITTING, CAUSING THE LC-063G-1SS SPRING (OR EQUIVALENT) TO BE OVERLY COMPRESSED.

SOLUTION:

IT IS ACCEPTABLE TO LOWER THE SUPPORT ASSEMBLY BY INSTALLING UP TO QTY (3) AN970-4 WASHERS BETWEEN THE 206-033-108-001 FITTING (OR EQUIVALENT) AND THE 206-050-223-001 SPACER (OR EQUIVALENT). SEE FIGURE BELOW FOR REFERENCE.



CROSSTUBE SECTION: SUPPORT DETAIL

PARTS LIST:

THE FOLLOWING PARTS HAVE BEEN INCLUDED WITH D206-667-103 CROSSTUBES AT CHG 004 AND SUBSEQUENT

ITEM	Qty -103	PART NUMBER	DESCRIPTION					
60	`12 -	AN970-4	WASHER					

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE:
08.12.17
CERT. NO.:
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